

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-015005**Date Inspected:** 12-Jun-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Xu Tao**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG COMPONENT**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Subhasis Bera was present during the times noted above for observations relative to the work being performed.

In process Inspection

Out Side

This QA Inspector observed the following work in progress:

SMAW in the 3G position for the OBG Segment 11DW , weld No. SEG067E-173. The welder is identified as #045268. ZPMC QC is identified as Mr. Li Ping. The welding variables recorded by QC appear to comply with WPS-B-P-2213-Tc-U4b-FCM-1.

SMAW in the 3G position for the OBG Segment 11BW , weld No. SSD11A-PP99-181. The welder is identified as #054013. ZPMC QC is identified as Mr. Tang Ya Jun. The welding variables recorded by QC appear to comply with WPS-B-P-2213-Tc-U4b-FCM-1.

SMAW in the 4G position for the OBG Segment 12AW , weld No. SEG3004A-005. The welder is identified as #066038. ZPMC QC is identified as Mr. Li Ping. The welding variables recorded by QC appear to comply with WPS-B-P-2214-Tc-U4b-FCM-1.

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This QA Inspector observed the following work in progress:

FCAW in the 2F position for the OBG Segment 13CE , weld No. SP3065A-071/072. The welder is identified as #055491. ZPMC QC is identified as Mr. Wang Xu . The welding variables recorded by QC appear to comply with WPS-B-T-2132.

SAW in the 1G position for the OBG Segment 13AE bottom Plate, weld No. BP3031-001-001. The welder is identified as #0044780. ZPMC QC is identified as Mr. Guo Xing Hai. The welding variables recorded by QC appear to comply with WPS-B-T-2221-B-U3c-S-2.

Bay #16

This QA Inspector observed the following work in progress:

SAW in the 1G position for the OBG Segment 13AW bottom Plate, weld No. BP3074-001-003. The welder is identified as #045265. ZPMC QC is identified as Mr. Li Ming Yang. The welding variables recorded by QC appear to comply with WPS-B-T-2221-B-U3c-S-2.

Ultrasonic Testing (A,B,C and D-Scan)

This QA Inspector performed Ultrasonic testing (UT) 10% of the area previously tested and accepted by ZPMC Quality control personnel. This QA inspector generated a (UT) report for this date. The members are identified as portion Edge Splice joint between segments 8BW to 8CW at cross beam side. This Inspection was performed after ABF UT Inspectors performed UT of this joint. The result was recorded onto a data sheet according to rejection criteria of “D” Scan procedure that Caltrans QA and ABF QA have jointly filled out on this date.

The Weld Designation is as follows

OBW8A-005

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



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ZPMC personnel performing SMAW for weld joint
SEG067E-173 at 3G position on Crossbeam side
at segment 11DW



Summary of Conversations:

No relevant conversations

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

Inspected By:	Bera,Subhasis	Quality Assurance Inspector
Reviewed By:	Patterson,Rodney	QA Reviewer
